Date: Tuesday, 3/14/2006 9:59:05 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D205633015
Job Number	: 26230		
Estimate Number	: 10804		
P.O. Number	: N/A	**Part Number**	: D205633015
This Issue	: 3/14/2006 **S.O. No.** : N/A	**Drawing Number**	: REPACKAGE
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : N/A	**Drawing Revision**	: N/A
Previous Run	: 00015	**Material**	: N/A
Written By	: SEE ABOVE USER & DATE	**Due Date**	: 3/21/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	:		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT STEP
D205-633-015 B20839

2.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
ADD HARDWARE MISSING
2 X D2022-101 B 23396
2 X D2022-103 B 24271
1 X AN44-7A B m18034
1 X AN4-5A B m100089
3 X AN4-6A B m19078
2 X AN4-7A B m18369
1 X AN4-14A B m15072
1 X AN4-10A B m18057
1 X AN5-14A B m17566
14 X AN960JD416 B m19085
4 X AN960JD516 B m18100
8 X MS21042L4 B m17997
2 X MS21042L5 B m19073

see attached for balance of kit

CL 06/03/14 ① P.T.O for reference CL

3.0	D2022101	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spacer

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Customer: CC-DAR01 Dart Aerospace Ltd. **Drawing Name:** D205633015

Job Number: 26230 **Part Number:** D205633015

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	D2022103	Spacer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Spacer	
5.0	AN447A	BOLT
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) BOLT	
6.0	AN45A	Bolt
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt	
7.0	AN46A	Bolt
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt	
8.0	AN47A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Bolt	
9.0	AN414A	Bolt
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt	
10.0	AN410A	Bolt
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt	
11.0	AN514A	Bolt
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt	

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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd. **Drawing Name:** D205633015

Job Number: 26230 **Part Number:** D205633015

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	AN960JD416	Washer
	Comment: Qty.: 14.0000 Each(s)/Unit Total : 28.0000 Each(s) Washer	
13.0	AN960JD516	Washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s) Washer	
14.0	MS21042L4	Nut
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s) Nut	
15.0	MS21042L5	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Nut	
16.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	6/3/14 REV C
17.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 REPACKAGE PER PPP REV. C	6/3/14
18.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL	06/03/15

Job Completion 06.03.15

 Form: rprocess

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REFERENCE ONLY

DART AEROSPACE LTD	Work Order:	20839
Description: Heli Access Step	Part Number:	D205-633-015
Dwg:	Qty:	2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travellers for: Batch D205-633-015 Heli Access Step 20839 D2563 Step Weldment Ass'y 20839	KJ	04.05.07	2
2	DC	Photocopy blue file and create labels per PPP D205-633-015 ~~CHG001~~ CHG 002 RF 03.01.08 UK 20 KJ	KJ	04.05.07	2
3	PK	**Pick: Packing Kit**	CAP	04/05/10	2
4	PK	**Pick:** Qty Part Number Description Batch 1 D2563 Weldment Ass'y B20839	CAP	04/05/14	2
5	QC4	Inspect 100% Kit for Completeness	U	04.05.10	2
6	PK	Identify and pack for shipping as per PPP D205-633-015 Rev F U	CJ	04/05/14	2
7	AC	Cost / part £70.35	SUC	04.05.26	2
8	DC	Close work Order and Ensure Travellers Attached Inspect Level 21 £43.31 Travellers: D205-633-015 D2563	KJ	04.05.07	2

Step 3 Packing Kit:

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	B19265
2	D2022-103	Spacer	B16062
1	D2562-005	Strut	~~B20607~~ → B23224
1	D2565-301	Strut	B20608
1	D2565-303	Strut	B20609
1	D2565-305	Strut	B20610
1	D2565-307	Strut	B20611
1	D2565-309	Strut	B20612
1	~~D2565-311~~ D3165-1	Strut	B20617
1	AN44-7A	Eyebolt	M14783
~~2~~ 1	AN4-5A	Bolt	M14149 / M13536
~~2~~ 3	AN4-6A	Bolt	M13943
2	AN4-7A	Bolt	M13884
1	AN4-14A	Bolt	M14600
1	AN4-10A	Bolt	M11045
1	AN5-14A	Bolt	M11921
14	AN960JD416	Washer	M14312
4	AN960JD516	Washer	M14076
8	MS21042L4	Nut	M14149
2	MS21042L5	Nut	M5289

04.03.24

Rev	Date	Change	Revised By	Approved
A	02.06.10	New Issue	NG	
B	02.07.31	Re-Format	KJ RF	

BB 04.05.18 DB

REFERENCE ONLY

UNDER REVIEW 02/09/17 RF

RELEASED 02/08/15 RF

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REFERENCE ONLY

DART AEROSPACE LTD	Work Order:	20839
Description: Step Weldment Ass'y	**Part Number:**	**D2563**
Drawing: D2563 Rev. B	**Qty:**	2

RF 03.08.11

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	RF	04.05.07	2
2	WA	Cut D2244 to 89.70" at 34° as per Dwg D2563 Batch: B17840	SB	04/05/10	2
3	WA	Deburr ends	SB	04/05/10	2
4	QC5	Inspect for foreign object per QSI 024		04.05.10	2
5	WA	**Pick:** Qty Part No. Description Batch 2 D2673-34 End Cap B20161 2 D2561 Lug Plate B20606 2 D2564 Mounting Angle B204614	AS	04/05/11	2
6	WA	Weld as per Dwg D2563 using DT 8343	AS	04/05/11	2
7	WA	Grind	DB	04/05/11	2
8	QC9 & 5	Inspect Welding and work to Step 7		04.05.11	2
9	FP	Powder Coat White (Ref. 4.3.5.1) per Dart QSI 005 4.3	M	04.05.11	2
10	QC3	Inspect Powder Coat		04.05.11	2
11	FP	Wing Walk as per Dwg D2563 and QSI 005 4.4		04.05.13	2
12	QC3	Inspect Wing Walk	M	04.05.13	2
13	FP	To KP for packing	M	04.05.13	2

Rev	Date	Change	Revised By	Approved
A	97.01.14	New Issue		
B	98.05.21	Updated end plate, added steps 8-10	KB	
C	99.02.10	Added Drawing Rev	DM	
D	99.05.06	Moved Insp. Level 9, Re-format	DM	
E	00.05.08	Removed P/O for powder coating	EC	
F	00.07.20	Added inspection for QSI 024	EC	
G	02.07.31	Re-format Location	RF RF	

RELEASED 02/08/02 RF

REFERENCE ONLY